

WORK ORDER 2010-08

Date opened: 15 April 2010

Project: Quick Release Cargo Basket Assembly
Type: Bell 206L Series, 407Batch Quantity: 1 Complete Basket Assembly (69810-01)
Modified with Open Front End (70405)Approval: SH00-48
Drawing List: DCL698-1, DCL704

Fabrication and Assembly Drawing(s)	Description
69810, Rev. 2	Basket Ass'y
69811, Rev. 2	Basket Body Ass'y
69812, Rev. 1	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 1	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
70404, Rev. 0	Open Front End Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: _____ Date: _____

Drawing: 69810 Revision 2
 Assembly: 69810-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	69810-01	Cargo Basket Assembly			
1	69811-01	Basket Body Assembly	Below		
1	69812-01	Basket Lid Assembly		WO2008-10	
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8093	
1	MS20001P4	Piano Hinge		8104	
1	69827-01	Placard	0.063" Sheet, 6061-T6 Aluminum	8062	
3	49205-14	Bumper	Argus Industries Bumper	8071	
26	CR3213-4-02	Cherry Rivet		8073	
4	40088-14	Fitting	Ancra	8077	
4	AN960-616	Washer		8067	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		7077	
4	AN960-10	Washer		8048	
2	AN970-3	Washer		8067	
2	MS21044N3	Nut		7077	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		
Final Inspection	Drawing 69810			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69811 Revision 2
Assembly: 69811-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	69811-01	Basket Body Assembly			
2	69821-01	End Hoop (Rev. 1)	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
4	69823-02	Lug	1018 Mild Steel, 5/8" Rod	8022	
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
4	69825-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
2	69826-01	Strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	8022	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69811			
Final Inspection	Drawing 69811			



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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below	—	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	8058	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		8048	
2	MS21044N3	Nut		7077	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			gc.

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	8076	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Monel Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			gc.

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			


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Drawing: 70404 Revision 1
Assembly: 70404-01 Open Front End Modification


Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	70404-01	Open Front End Modification			
1	70404-03	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	70404-04	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	8064	
1	3/4-16F	Mesh	Expanded Carbon Steel	8094	

Note: Remainder of assembly listed on drawing 69811

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70404			

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1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice 2010-08
6. Item	7. Description Cargo Basket	8. Part Number 69810-01	9. Qty. 1	10. Serial/Batch No. 69801-30	11. Status/Work New
12. Remarks Modified with front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 08 Dec 2010		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

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